

Work Order ID 82740

82740

Page 1

April-05-12 12:57:41 PM

Item ID: D3766-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rear Rail

Start Date: 05/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/05 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3766	Rev B								
100	Small Fab	0.00							
100									
Small Fab									
Small Fab	Memo	0.00							
	1-cut tube to length as per dwg D37662-drill holes thru to finish size as per dwg D3766 using DT9413 ,Drill holes labelled #3.3- deburr								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC									
Quality Control	Memo	0.00							
120	Chemical Conversion Coat per QSI005 4:1	0.00							
120									
HandFinish									
Hand Finishing	Memo	0.00							

4

12-04-16

5/12/05

(X)

(4) 12/4/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

Item ID: D3766-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Rear Rail

Stop ***NS2***

Start Date: 05/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

4X

✓

M-A
12/04/17

140

Identify as per dwg & Stock Location: 254

0.00

140

Packaging

Memo

0.00

Packaging

(42)

12/4/18

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/4/19

mf
12-04-18

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Picklist Print

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Page 1

Work Order ID: 82740

82740

Parent Item: D3766-3

D3766-3

Parent Item Name: Rear Rail

Start Date: 05/04/2012

Required Date: 20/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 08-07-21 revB as per dwg DD verified by:EC
IPP Rev:B Added Drilling Tooling 08-08-27 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W.188		Purchased		No		100	f	79.6624	2.7927	11.75874			

M6061T6T1 000W 188

6061T6 RD TUBE 1.00 X .188W

**

(4) 12-04-16

Location

MAT016

Loc Qty

79.662368

Loc Code

109041

3

114089

0.227368

115868

1.435

117797

3

120935

72

11.75874

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D3766-1 FRONT RAIL, LH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82740 MLJ
12/04/05

D3766-2 FRONT RAIL, RH

D3766-3 REAR RAIL

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3766-1, 1.55 lbs
D3766-2, 1.55 lbs
D3766-3, 1.55 lbs

B	CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3766	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RAIL	NTS
DATE	08.06.10	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

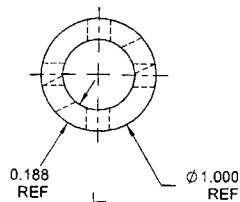
W/O:		WORK ORDER CHANGES					
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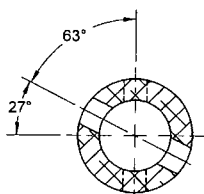
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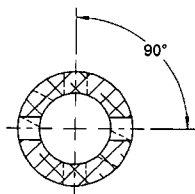
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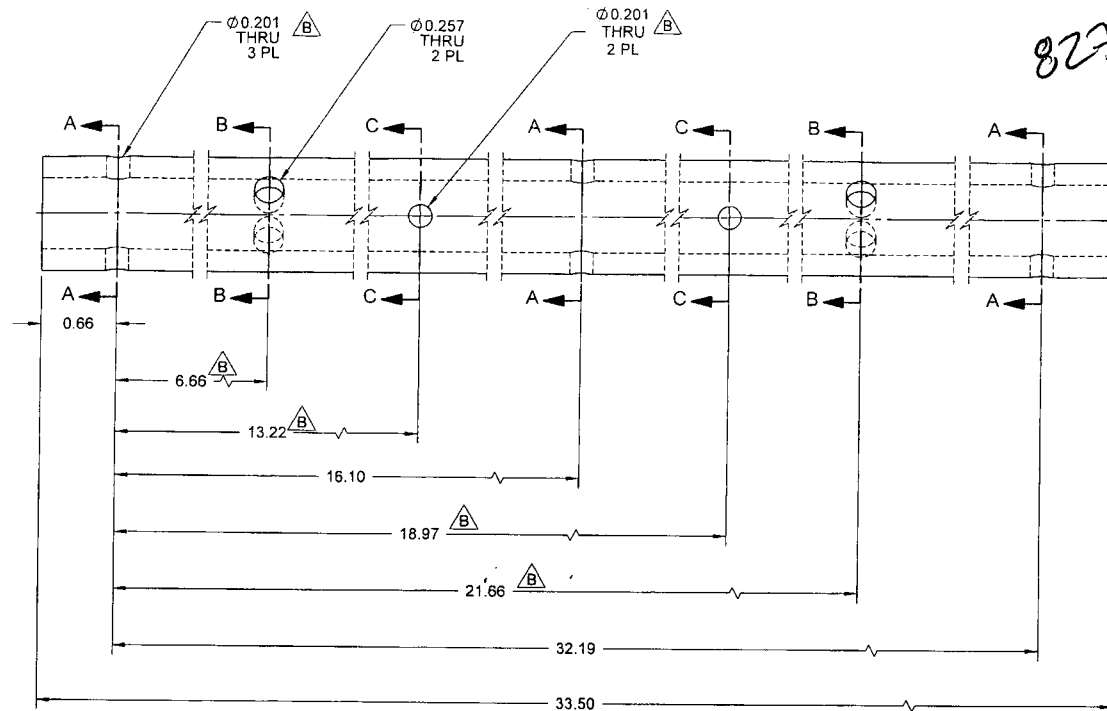
SECTION A-A



SECTION B-B



SECTION C-C



D3766-1 FRONT RAIL, LH

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82740

RELEASED
11/08/07/10

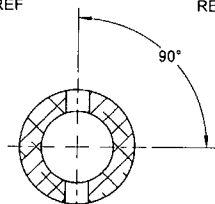
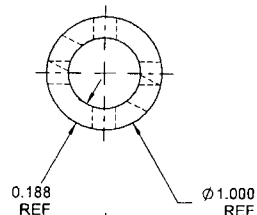
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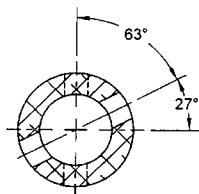
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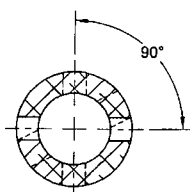
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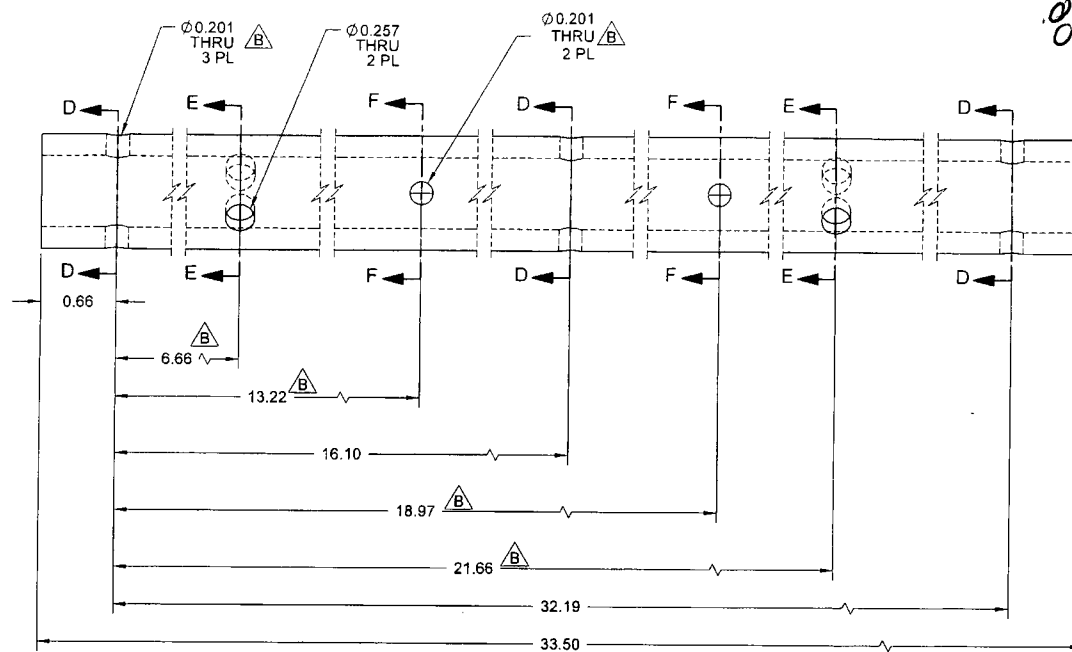
SECTION D-D



SECTION E-E



SECTION F-F



D3766-2 FRONT RAIL, RH

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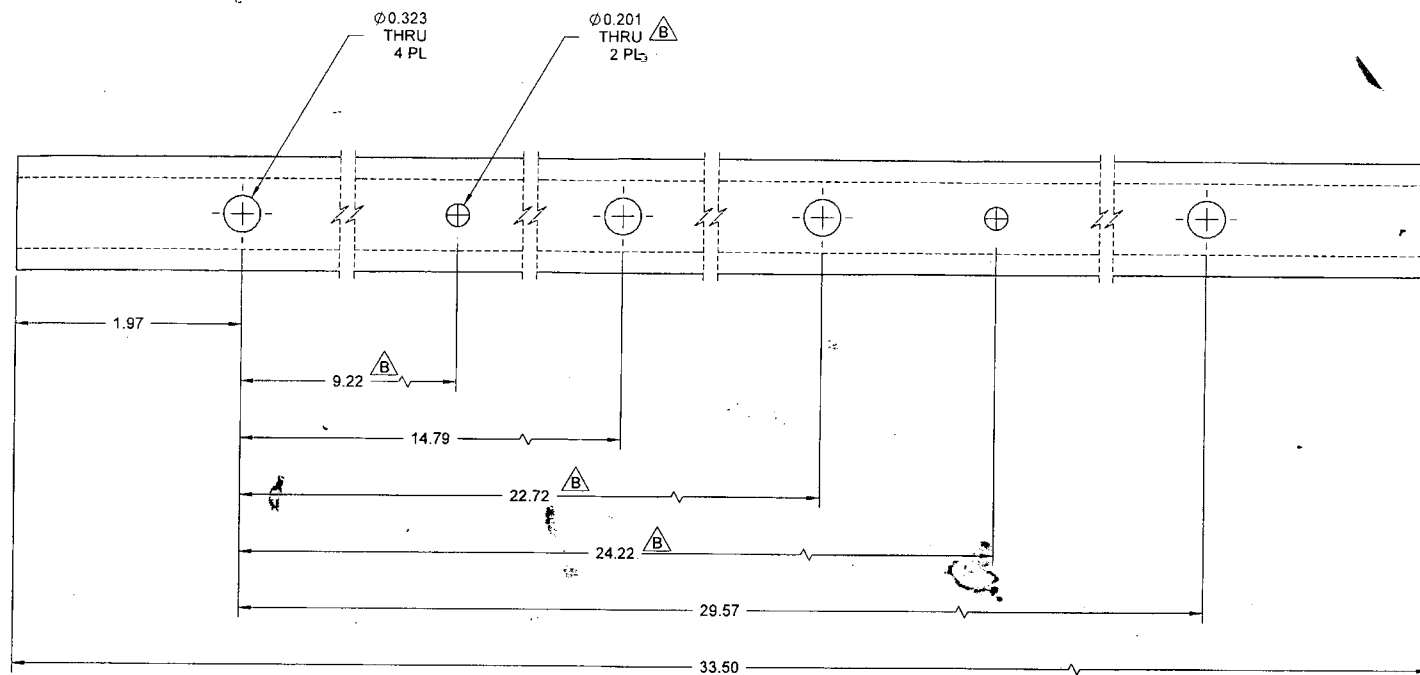
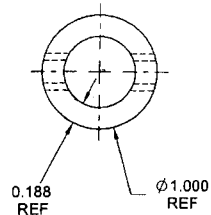
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D3766-3 REAR RAIL

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